

Friday, 14/11/2008 9:15:13 AM Linda Lacelle

Process Sheet

User Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLIDING DOOR BRACKET Job Number : 43440 **Estimate Number** : 13643 : D36753 Part Number P.O. Number - D3675 REVE PRELIM : 14/11/2008 Drawing Number S.O. No. : This Issue Prsht Rev. : NC Project Number : PRELIM B : 11 : SMALL /MED FAB **Drawing Revision** First Issue Type Material Previous Run Qty: 2 Um: : 17/11/2008 Due Date Written By Checked & Approved By 08-11.06 EC verified by:DD : Est Rev:A new issue

Additional Product

1.0

Job Number:





Each

Description: Seq. #: Machine Or Operation:

M304S20GA

NOT pullED

Comment: Qty.: 0.2541 sf(s) 0.1271 sf(s)/Unit_ Total:

304 stainless steel 0.032" Sheet

B 8-11-17 Batch: 10905

2.0

FLOW WATER JET

304/316 .040 Sheet



Comment: FLOW WATER JET 1-Cut as per Dwg D3675

Dwg Rev: PRE

IR 8-11-17

Prog Rev:___ PRE

2-Deburr if necessary

B8-11-17

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-11- 17



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK



BRAKE NC

10611.18 (3)



Comment: SECOND CHECK

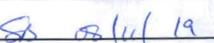
5.0

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3675



Dart	Aeros	pace	Ltd
		Perce	

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCI	EDURE CHAN	NGE	By Date Qty Chief Er			Approval Chief Eng / Prod Mgr Approval QC Inspector	
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Part No		PAR #:	Fault Categ	Jory:	NCR: Yes	No DQA:	Date: _		
		olution:							
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC Corrective Action			on B	Verification	Approval	Approval	
DATE	STEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
			m 2						
	0								
			100						
		39							

Friday, 14/11/2008 9:15:13 AM Date: User: Linda Lacelle **Process Sheet** Drawing Name: SLIDING DOOR BRACKET Customer: CU-DAR001 Dart Helicopters Services Part Number: D36753 Job Number: 43440 Job Number: Seq. #: Machine Or Operation: Description: INSPECT WORK JA CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 7.0 POWDER COATING Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE** FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 240

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSP

Job Completion

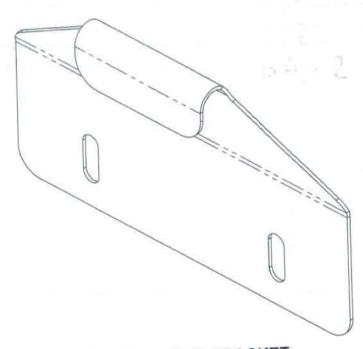


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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:						
	Res	solution:	Disposition	n:	QA: N/C Clo	osed:	Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (NCR)		
	STED Description of NC		Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector

PRELIMINARY ISSUE

ASS 08.11.04



D3675-3 SLIDING DOOR BRACKET (HINGE PANEL MOD)

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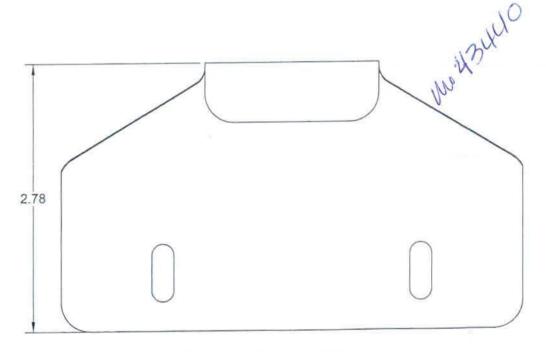
			NEL MOD	AJS	08.11.03		
В	ADD -3	FOR HINGE PA	NEL MOD.	AJS	08.03.27		
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DE APPR.			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTLY, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT. THIS DOCUMENT IS PRIVATE AND CONFIDENTLY, AND IS CHARAGED TO ANY OTHER PERSON WITHOUT THIS DOCUMENT IS PRIVATE AND CONFIDENT OF COMMUNICATION TO THEIR PERSON WITHOUT THIS DOCUMENT IS PRIVATE AND CONFIDENT OF COMMUNICATION TO THEIR PERSON WITHOUT THE DOCUMENT OF THE PERSON OF THE PERSON WITHOUT THE DOCUMENT OF THE PERSON OF THE PERSON WITHOUT THE DOCUMENT OF THE PERSON OF THE PERSON WITHOUT THE DOCUMENT OF THE PERSON OF THE PERSON WITHOUT THE DOCUMENT OF THE PERSON OF THE PERSON WITHOUT THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON WITHOUT THE PERSON OF THE PERSON				
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DO	A:	_ Date: _	
	Re	esolution:	Disposition	on:	QA: N/C	losed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	CTED	Description of NC	scription of NC Corrective Action Se			Veri	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	Section C	Chief Eng	QC Inspector

2.78

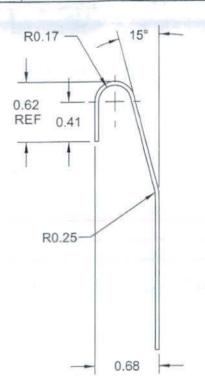
D3675-1 SLIDING DOOR BRACKET (MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET (MAKE FROM D3675-3F) (HINGE PANEL MOD)

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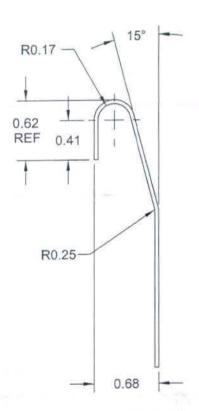
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STEP	PRO	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Reso						Date: _	-
	V	WORK ORDE	R NON-CONFORMA	NCE (NCR)		
CTED	Description of NC		Corrective Action Section B		Verification	n Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			QC Inspector
		PAR #:	PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A STEP Section A Initial Action Description Sign &	STEP PROCEDURE CHANGE By Date Question Section A PAR #: Fault Category: NCR: Yes No DQA:	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr PAR #: Fault Category: NCR: Yes No DQA: Date: _ Resolution: Disposition: QA: N/C Closed: Date: _ WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Section C Section C Chief Eng / Prod Mgr



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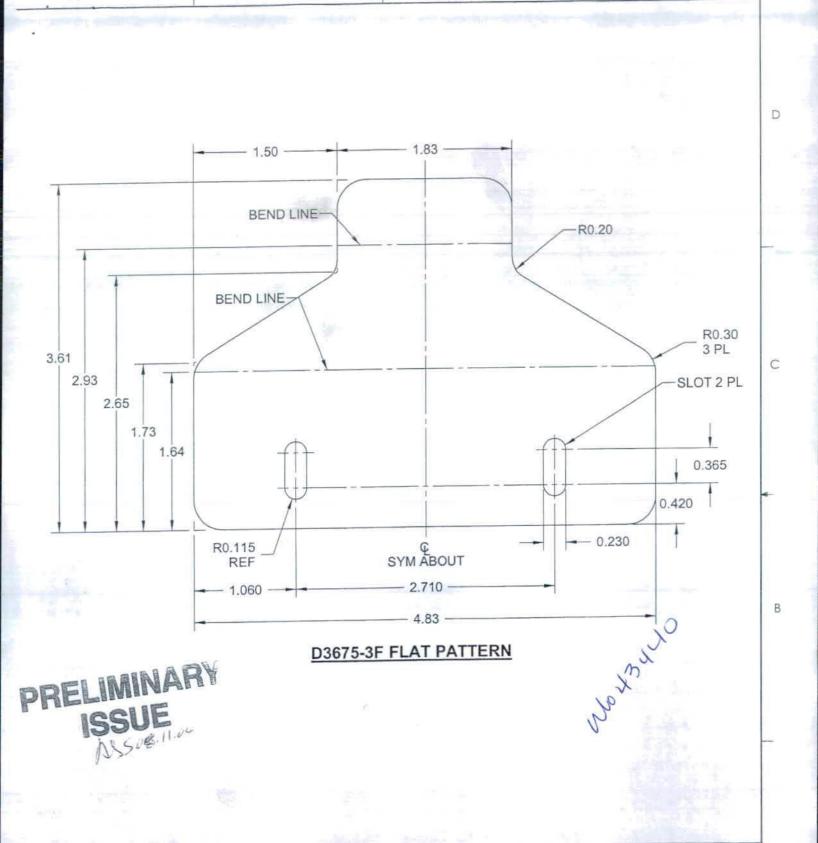
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DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA					
CHECKED	0	DRAWING NO.	REV. B				
MFG. APPR.	1	D3675	ET 2 OF 3				
APPROVED	111	TITLE SLIDING DOOR BRACKET	SCALE				
DE APPR.	0.0	(COMPOSITE DOOR)	NTS				
DATE 08.11.03		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPORNTIAL AND IS SUPPLIED ON THE EXPRESS CONCIDENT THAT IT IS NOT TO SE USED FOR ANY PURPOSE OR COPED OR COMMUNICATED TO JAVY OTHER PERSON WITHOUT WRITTEN PERSONNEY OR DART AEROSPACE LTD.					

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		(COMPOSITE DOOR)	NTS			
DATE 08.1	1.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPRISHING, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO SE USED FOR ANY PURPOSE OR COMPANIONATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

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DART AEROSPACE LTD	Work Order:	43440	
4,			
Description: SLIDING POOR BRACKEY	Part Number:	D3675-3	
Inspection Dwg: 03675-3 , Rev: pRF. L.		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
. 230	4610	.234	8		2	
,365	4 010	.365	Xe.	-		
.430	4010	1420	8		***	
4.83	4- ,030	4.933	X			1
1.060	4- 010	1.060	X			
1.50	4- 020	1.498				
1.83	4030	1.830	M	dia.		
3.61	4- 030	3.610-	*			1
1.73	4030	1,73	8			
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Measured by: | Audited by: | Prototype Approval: | Date: | Dat

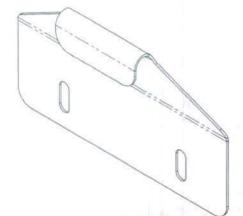
Rev	Date	Change		Revised by Appro	ved
1464	Date		THE PERSON NAMED IN COLUMN TWO IS NOT THE OWNER.	KJ/JLM	
A		New Issue			



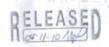
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D3675-1 SLIDING DOOR BRACKET

Mo 43440



D3675-3 SLIDING DOOR BRACKET (HINGE PANEL MOD)



(COMPOSITE DOOR)

- 8	ADD -3 FOR HINGE PANEL MOD. NEW ISSUE		AJS	06.11.03				
A			AJS	08.03.27				
RÉV.	1111		DESCRIPTION	BY	DATE			
DESIG	N.	AJS	DART AERO	DART AEROSPACE LTD				
DRAW	N	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECK	(ED	A	DRAWING NO.		REV. B			
MFG, APPR. /2		12	D3675		SHEET 1 OF 3			
APPRO	PPROVED AND		TITLE SLIDING DO	OR BRACK	ET SCALE			

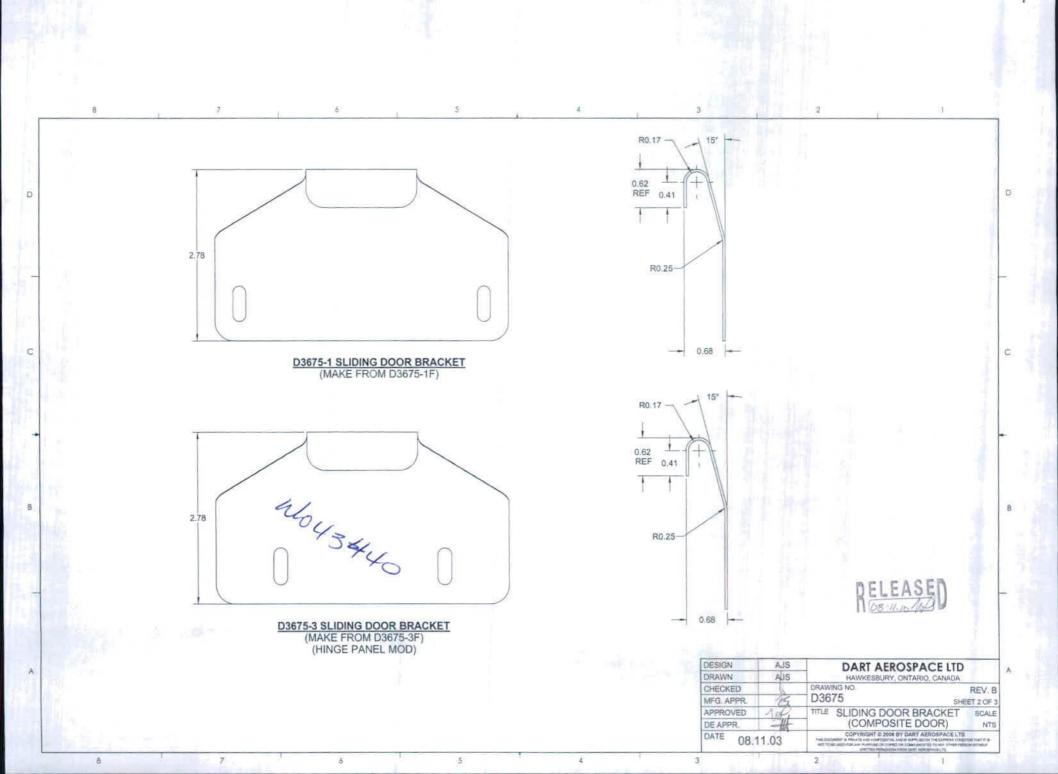
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF, DART SPEC M304S
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.15 lbs:
ALTHE D3475-1 SUDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET. 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK

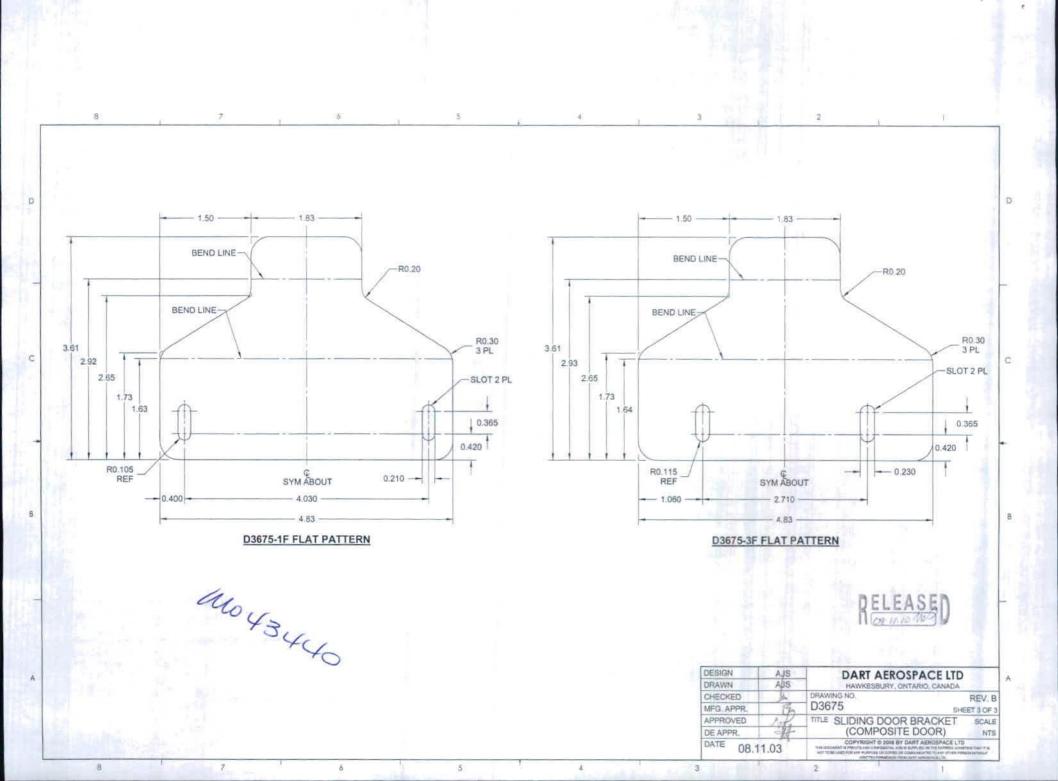
DE APPR.

DATE 08.11.03

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